

# Work Order ID 72919

Thursday, August 18, 2011 10:06:21 AM



Page 1

Item ID: D3280-1L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, LH

Stop



Start Date: 8/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11/08/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3280

Rev E

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

X3

OK  
11/08/18

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:30pm

11/08/18

Time OUT: 7:00am

11/08/19

X3

OK  
10/08/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72919**

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Page 2

Item ID: D3280-1L08

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Item Name: Floor Protector, LH

Start Date: 8/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	THERMOFORMING MACHINE					x3			DL 11/08/19
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3280 and Folio FTA 011 Dwg. Rev. <u>E</u> Folio Rev. <u>C</u>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB					x3			DL 11/08/19
QC	Memo	0.00							
Quality Control									
130		0.00							
	HAND FINISHING THERMOFORMING					x3			DL 11/08/23
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72919

Thursday, August 18, 2011 10:06:21 AM



Page 3

Item ID: D3280-1L08

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Revision ID:

Item Name: Floor Protector, LH

Stop



Start Date: 8/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x3			Wk 11/08/23
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							Sulos/23
Quality Control									
160	Packaging	0.00							
Packaging	Memo	0.00							
Packaging									ppp 72916

(x3)

(3x)

Sp 11-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72919**

Thursday, August 18, 2011 10:06:21 AM

Page 4

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Revision ID:

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Item Name: Floor Protector, LH

Start Date: 8/18/2011 Start Qty: 2.00

Required Date: 8/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/01  
MF  
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, August 18, 2011 10:06:26 AM

Page 1

Work Order ID: 72919



Parent Item: D3280-1L08



Parent Item Name: Floor Protector, LH

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. C Added colour cde to D3280-1 11/03/03 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,874.382	4.333	9.122105			



Lexan Sheet

Location

Loc Qty

Loc Code

therm

1874.382621

1874.38262

113127

12.999 sf Pt.

Dh  
11/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	72919
<b>Description: R22 Floor Protector, LH</b>	<b>Part Number:</b>	D3280-1
<b>Inspection Dwg: D3280 Rev: E</b>		<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" <i>M</i>	<i>✓</i>			
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

<b>Measured by:</b>	<i>DR</i>	<b>Date:</b>	11/08/19 <i>DR</i>
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**TRIMMING SECTION**

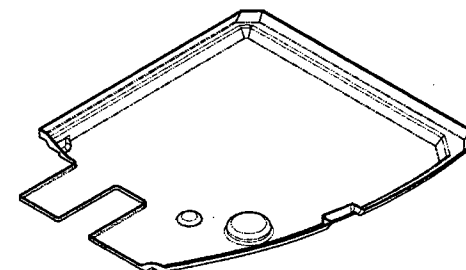
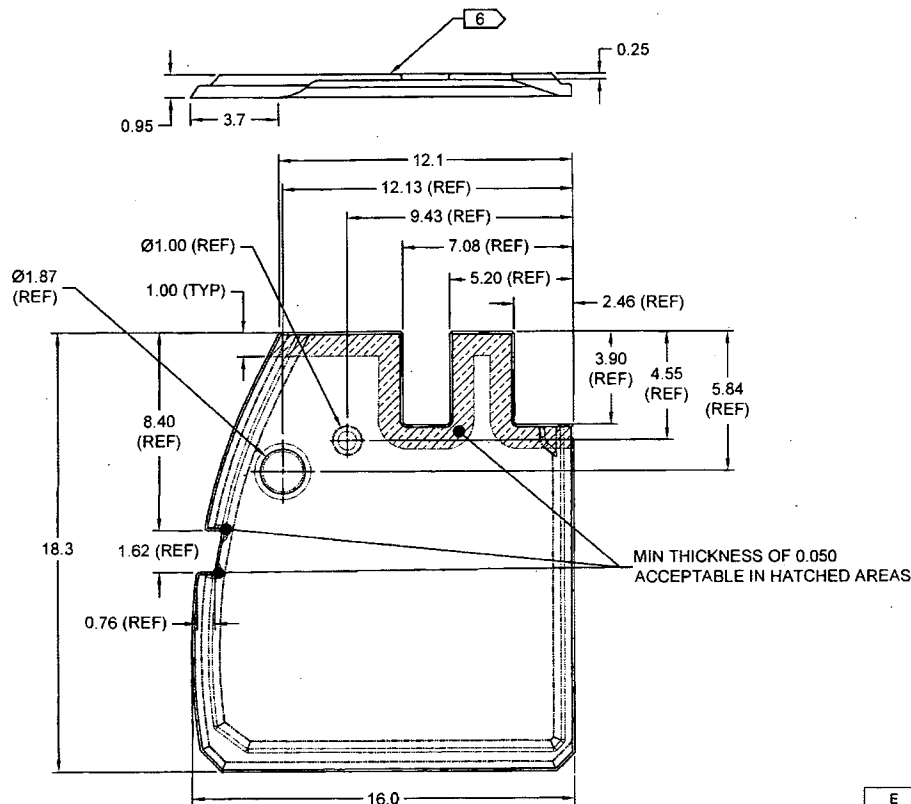
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3"	<i>✓</i>		Tape DL-01	
16.0	+/-0.100	15.9"	<i>✓</i>		Tape DL-01	
12.1	+/-0.100	12.1"	<i>✓</i>		Tape DL-01	
0.95	+/-0.030	0.970"	<i>✓</i>		Visual TH-01	
0.25	+/-0.030	0.269"	<i>✓</i>		Visual TH-01	
0.070	Min	0.115"	<i>✓</i>		ULTRA	
0.050	Min	0.086"	<i>✓</i>		ULTRA	

<b>Measured by:</b>	<i>DR</i>	<b>Date:</b>	11/08/23
<b>Audited by:</b>	<i>JB</i>	<b>Date:</b>	11/08/23
<b>Preliminary Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	11.04.28	Dwg Rev updated	KJ	<i>DR</i>

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72919

*PH 11-08-18*



**RELEASED**  
2011-03-02  
*MP*

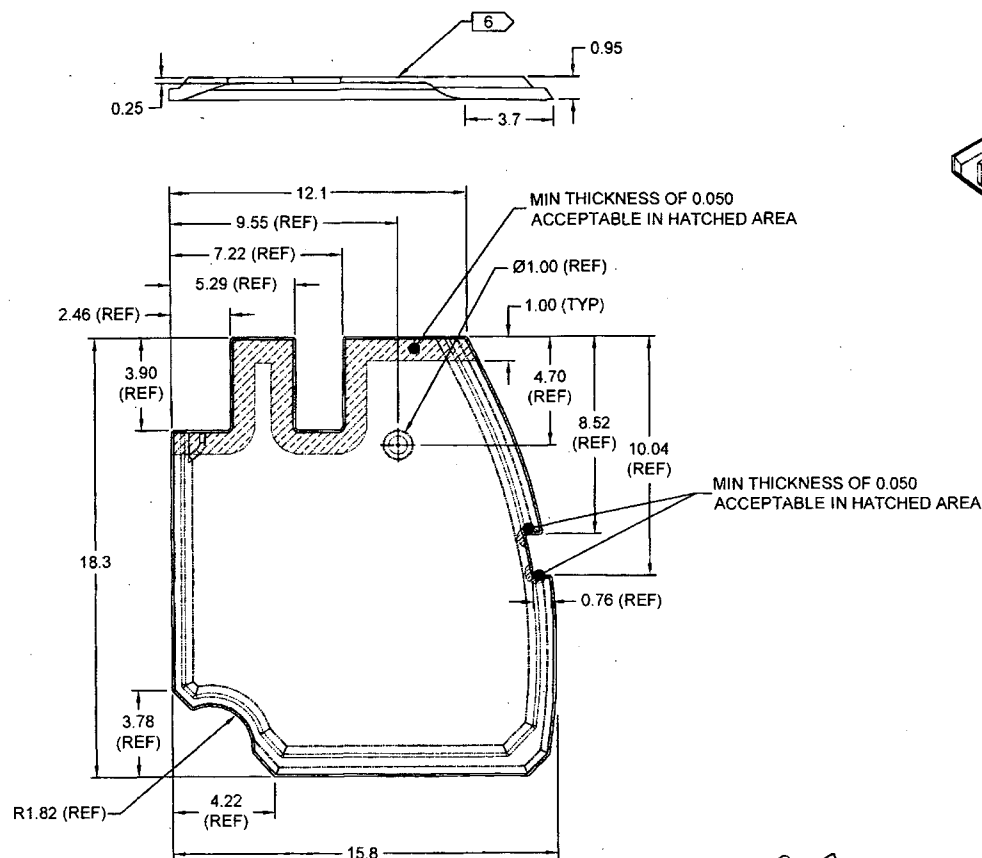
**D3280-1 FLOOR PROTECTOR**

**D3280-1 NOTES:**

- 1) MATERIAL: -1L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
-1L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1Lxx" AND B/N PER QSI 044 6.4
- 7) WEIGHT: D3280-1L02 = 0.94 lb D3280-1L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



E	REVISE NOTES (ZN A8-1, A8-2)	RF	11.03.01
D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>MP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>MP</i>	D3280	SHEET 1 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	FLOOR PROTECTOR	NTS
DATE	11.03.01	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3280-3 FLOOR PROTECTOR**

**D3280-3 NOTES:**

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3Lxx" AND B/N PER QSI 044 6.4
- 7) WEIGHT: D3280-3L02 = 0.88 lb D3280-3L08 = 1.03 lb
- 8) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



72919

**RELEASED**  
2011-03-02

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. E
MFG. APPR.	40	D3280	SHEET 2 OF 2
APPROVED	40	TITLE	SCALE
DE APPR.	40	FLOOR PROTECTOR	NTS
DATE	11.03.01	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	